



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

5062571
DSK078

Job Sheet 176223



Part No: DSK078

Job Qty: 12 ea

Part Name: D2893-1 Turning Detail



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/19/18

Job Tracking No:

Due Date: 4/27/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP rev A. 08.03.13 new issue EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea		4/27/18	0.00	0.00	Start Up Machining-4		
100	Doosan	12 pcs		4/27/18	0.50	10.53	Doosan		
110	QC	12 pcs		4/27/18	0.00	0.00	QC2 Machining-4		
120	QC	12 pcs		4/27/18	0.00	0.00	QC8 Machining-4		
130	Packaging	12 pcs		4/27/18	0.00	0.00	Packaging3-2		
140	QC21-SA	12 Ea		4/27/18	0.00	0.00	QC21		

Part Op 100 - Turn blank as per Folio FA081 (4TH AXIS PLUG DT8492)
Descriptions: 130 - LOCATION: MAT060

18/06/11
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18/06/11
JUN 11 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6104-005	Round Billet, 17-4	12 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6104-005	12	32	0

Part Specifications

Specifications could not be found.

Plex 4/19/18 7:04 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

DART AEROSPACE LTD		Work Order: 176223
Description: Turning Detail for D2893-1		Part Number: DSK078
Inspection Dwg: DSK078	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.707	2.712		2.710	2.710	2.710	2.710	2.710
B	4.946	4.966		4.955	4.955	4.955	4.955	4.956
C	3.064	3.084		3.074	3.074	3.074	3.074	3.075
D	0.718	0.738		0.728	0.728	0.728	0.728	0.728
E	0.090	0.110		0.097	0.100	0.100	0.100	0.100
F	2.934	2.954		2.945	2.945	2.944	2.944	2.944
G	2.166	2.186		2.176	2.176	2.176	2.176	2.176
H	3.890	3.910		3.900	3.900	3.900	3.900	3.900
I	0.914	0.934		0.924	0.924	0.924	0.924	0.924
J	0.022	0.042		0.032	0.032	0.032	0.032	0.032
K	0.109	0.129		0.118	0.118	0.118	0.118	0.118
L								
M								
N								
O								
P								

Measured by: *[Signature]* **Date:** 18/06/10

Audited by: *[Signature]* **Date:** 18/06/11

Prototype Approval: **Date:**

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<i>[Signature]</i>

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

DART AEROSPACE LTD		Work Order: 176223
Description: Turning Detail for D2893-1		Part Number: DSK078
Inspection Dwg: DSK078	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ **First Article**
☐ **Prototype**

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6	7	8	9	10
Lathe Section								
A	2.707	2.712		2.710	2.710	2.709	2.709	2.709
B	4.946	4.966		4.956	4.956	4.956	4.956	4.955
C	3.064	3.084		3.074	3.074	3.075	3.075	3.075
D	0.718	0.738		0.728	0.728	0.728	0.728	0.728
E	0.090	0.110		0.100	0.100	0.100	0.100	0.100
F	2.934	2.954		2.944	2.944	2.944	2.944	2.944
G	2.166	2.186		2.176	2.176	2.176	2.176	2.176
H	3.890	3.910		3.900	3.900	3.900	3.900	3.900
I	0.914	0.934		0.924	0.924	0.924	0.924	0.924
J	0.022	0.042		0.032	0.032	0.032	0.032	0.032
K	0.109	0.129		0.118	0.118	0.118	0.118	0.118
L								
M								
N								
O								
P								

Measured by: <i>[Signature]</i>	Date: 18/06/10
Audited by: <i>[Signature]</i>	Date: 18/06/11
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

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WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By					
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : ☐			
Misidentified ☐		Past Due ☐					

DART AEROSPACE LTD		Work Order:	176223
Description: Turning Detail for D2893-1		Part Number:	DSK078
Inspection Dwg: DSK078 Rev: A		Page 1 of 1	

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☒ **First Article**

 ☐ **Prototype**

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	11	12			
Lathe Section								
A	2.707	2.712		2.709	2.709			
B	4.946	4.966		4.956	4.956			
C	3.064	3.084		3.075	3.075			
D	0.718	0.738		0.728	0.728			
E	0.090	0.110		0.100	0.100			
F	2.934	2.954		2.944	2.944			
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H	3.890	3.910		3.900	3.900			
I	0.914	0.934		0.924	0.924			
J	0.022	0.042		0.032	0.032			
K	0.109	0.129		0.118	0.118			
L								
M								
N								
O								
P								

Measured by: [Signature]
Date: 12/06/10

Audited by: [Signature]
Date: 12/06/11

Prototype Approval: _____
 Date: _____

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	[Signature]



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CANADA
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www.dartaerospace.com

Container No: S079545



Part: DSK078

Job No: 176223

Serial No/Batch: S079545

Revision:

Inspector:

Exp Date:

Instructions:

Date: 06/11/18